

# Work Order ID 78390

\*78390\*

Page 1

January-09-12 8:53:09 AM

Item ID: D206-642-213

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop \*NS2\*

Start Date: 09/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 23/01/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/01/09

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-642

O

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP206-642-213 CHG006

110

Pick Kit

0.00

\*110\*

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

\*120\*

QC

Memo

0.00

Quality Control

B83027

12/06/21

MLJ 12-6-18

12/06/21

12/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78390

\*78390\*

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January-09-12 8:53:09 AM

Item ID: D206-642-213 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube LH  
 Start Date: 09/01/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 23/01/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
*130*									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-213 Location: 82								
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

12/6/25  
 ME  
 120625

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## January-09-12 8:53:13 AM

**\*78390\***

**\*D206-642-213\***

**Required Date:** 23/01/2012

**Required Qty: 1.00**

IPP Rev:K05.07.14ECN 847 &amp; 901; Add Tow Ring and GHW

IPP Rev:L 07-12-04 ECN 1080p DD verified by: IPP rev M

10.02.02 per IIN rev M EC verified by: JLM IPP REV:N 11.11.17

PER IIN REVO DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-44A *AN6-44A* Bolt		Purchased	No			110	Each	337.0000	2	2			
				<u>Location</u>			<u>Loc Qty</u>						
				ST343			7						
					119127		7						
				st510			330						
					119036		330			119036			
AN960C416 *AN960C.416* washer	NAS1149C0463 R	Purchased	No			110	Each	0.0000	0	1			
AN960JD10 *AN960.ID10* Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	8	8			
AN960JD416 *AN960.ID416* Washer	NAS1149D0463J	Purchased	No			110	Each	0.0000	24	24			
AN960JD516 *AN960.ID516* Washer	NAS1149D0563J	Purchased	No			110	Each	0.0000	8	8			
AN960JD616 *AN960.ID616* Washer	NAS1149D0663J	Purchased	No			110	Each	0.0000	4	4			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78390

\*78390\*

Parent Item: D206-642-213

\*D206-642-213\*

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D206-642-241

Manufactured No

110 Each

0.0000

\*\*  1

\*D206-642-241\*

Replacement Skidtube

D206-651-041

Manufactured No

110 Each

0.0000

\*\*  1 ✓

\*D206-651-041\*

206A/B GHW

D2652

Manufactured No




110 Each

991.0000

\*\*  16 ✓

\*D2652\*

Bushing

83027   
83042 JB   
83744 JB 

## Location

## Loc Qty

## Loc Code

FG

44

31985

44

ST013

947

73834

15

73836

36

76132

96

76133

400

77135

400

D2665-1

Manufactured No


110 Each

12.0000

\*\*  1 ✓

\*D2665-1\*

Saddle, LH Fwd Aft Out 206

82374 JB 12/06/19 

## Location

## Loc Qty

## Loc Code

ST436

12

52306

8

55017

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 78390

**\*78390\***

Parent Item: D206-642-213

**\*D206-642-213\***

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2666-1

Manufactured No

110 Each

18.0000

**\*D2666-1\***

Saddle, LH Fwd Aft In 206

\*\*

1

1

80787 JB

Location

Loc Qty

Loc Code

ST426

18

52847

4

55018

6

60296

4

60870

4

D2667-1

Manufactured No

110 Each

5.0000

**\*D2667-1\***

Saddle, LH Aft Out 206

\*\*

1

1

60870 JB

Location

Loc Qty

Loc Code

ST427

5

42409

5

D2668-1

Manufactured No

110 Each

6.0000

**\*D2668-1\***

Saddle, LH Aft In 206

\*\*

1

1

42409 JB

Location

Loc Qty

Loc Code

ST427

6

40898

2

52348

4

D2712

Manufactured No

110 Each

1,642.000

**\*D2712\***

Set Screw

\*\*

5

5

52348 81871 JB 12/06/19

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1592

76065

1592

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 78390

\*78390\*

Parent Item: D206-642-213

\*D206-642-213\*

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2884  
\*D2884\*  
Saddle Spacer

Manufactured No

110 Each

367.0000

\*\*

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

357

76751

357

D2885  
\*D2885\*  
Saddle Spacer

Manufactured No

110 Each

358.0000

\*\*

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

348

76752

348

D3413-1  
\*D3413-1\*  
Ring

Manufactured No

110 Each

59.0000

\*\*

Location

Loc Qty

Loc Code

ST420

2

66387

1

70773

1

ST464

55

73822

3

75478

52

ST473

2

71041

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 78390

\*78390\*

Parent Item: D206-642-213

\*D206-642-213\*

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

6,189.000

8 38

\*\*

121349 JB

\*MS2104213\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

6189

117441

16

117885

32

118451

5

118927

3

119017

5610

119075

523

MS21042L4

Purchased

No

110

Each

8,007.000

12 12

\*\*

121444 JB

\*MS2104214\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

8007

117441

51

117601

342

118451

133

119017

2481

119075

5000

MS21042L5

Purchased

No

110

Each

2,050.000

2 2

\*\*

JB 12/06/19

\*MS2104215\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

2050

116105

5

116548

43

117611

50

118179

452

119109

1500

119109

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Work Order ID: 78390

\*78390\*

Parent Item: D206-642-213

\*D206-642-213\*

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

110

Each

1,146.000

2 2

\*\*

\*MS21042L6\*

Nut

Location

Loc Qty

Loc Code

ST300

1146

117677

25

118384

5

118927

48

118968

18

119075

1000

119736

50

119075

AN3-41A

Purchased

No

120

Each

959.0000

8 8

\*\*

\*AN3-41A\*

Bolt

Location

Loc Qty

Loc Code

ST354

959

119042

959

120498 JB

AN4-6A

Purchased

No

120

Each

3,572.000

12 12

\*\*

\*AN4-6A\*

Bolt

Location

Loc Qty

Loc Code

ST356

3572

119017

3572

121631 JB

12/06/19

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 78390

\*78390\*

Parent Item: D206-642-213

\*D206-642-213\*

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Purchased

No

120

Each

399.0000

1

\*\*

\*AN4C5A\*  
BOLT

## Location

## Loc Qty

## Loc Code

FP002

19

112243

19

ST355

380

112243

280

119017

100

AN5-11A

Purchased

No

120

Each

1,251.000

4

\*\*

\*AN5-11A\*  
Bolt

## Location

## Loc Qty

## Loc Code

ST337

1251

118191

13

119512

1238

AN5-32A

Purchased

No

120

Each

215.0000

2

\*\*

\*AN5-32A\*  
Bolt

## Location

## Loc Qty

## Loc Code

ST339

215

118422

2

118628

38

118983

25

119328

100

119862

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78390

\*78390\*

Parent Item: D206-642-213

\*D206-642-213\*

Parent Item Name: Skidtube LH

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-7A

Purchased

No

120

Each

2,821.000

4

\*AN5-7A\*

Bolt

\*\*

20 12/06/19

Location

Loc Qty

Loc Code

ST337

2821

117313

6

118422

1

119017

2814

119017

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 4.3 206A/B HIGH GEAR SKIDTUBES

ITEM	QTY -211	QTY -212	QTY -213	QTY -214	QTY -241	QTY -247	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
1	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-247	WEARSHOE KIT (REPLACES -243)
1	1	1	1	1			D206-651-041	* 206 GHW ADAPTER <sup>(1)</sup>
1					1		D2650-3	SKIDTUBE ASSEMBLY
2A					18		D2651-1	* PLUG <sup>(1)</sup>
2B					18		D2651-3	* O-RING <sup>(1)</sup>
3					1		D2646	* AFT CAP <sup>(1)</sup>
4					2		MS27039-1-08	* SCREW <sup>(1)</sup>
5					2		NAS1149D0332J	* WASHER <sup>(1)</sup> (OR AN960JD10L)
6	1		1	1			D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1		1	1			D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1						D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT, RH
9	1						D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3-41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21042-3	* NUT (OR MS21042L3)
12B	8	8	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4			AN5-7A	BOLT
14	4	4	4	4			AN5-11A	BOLT
14A			2	2			AN5-32A	* BOLT <sup>(2)</sup>
14B			2	2			MS21042-5	* NUT (OR MS21042L5) <sup>(2)</sup>
15	8	8	8	8			NAS1149D0563J	* WASHER (OR AN960JD516)
16	12	12	12	12			AN4-6A	BOLT
17	24	24	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12			MS21042-4	* NUT (OR MS21042L4)
20A					4	4	D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1	D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1	D3535-13	WEARSHOE (REPLACES D2656-13)
22B					1	1	D3536-13	GASKET
23A					1	1	D3535-21	WEARSHOE (REPLACES D2656-21)
23B					1	1	D3536-21	GASKET
24A					1	1	D3535-33	WEARSHOE (REPLACES D2656-33)
24B					1	1	D3536-33	GASKET
26A					44	44	MS27039C1-08	SCREW
26B					44	44	NAS1149C0332R	WASHER (OR AN960C10L)
26C					44		ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2			AN6-44A	BOLT
29A	2	2	2	2			MS21042-6	* NUT (OR MS21042L6)
29B	4	4	4	4			NAS1149D0663J	* WASHER (OR AN960JD616)
34	1	1	1	1			AN4C5A	BOLT
35	1	1	1	1			NAS1149C0463R	* WASHER (OR AN960C416)
36	1	1	1	1			D3413-1	RING (REPLACES D2655)
37	10	10	5	5			D2712	SET SCREW
38	2	2	2	2			D2884	SADDLE SPACER
39	2	2	2	2			D2885	SADDLE SPACER

NOTES: <sup>(1)</sup> DENOTES THAT PART IS INCLUDED WITH D2650-3 ASSEMBLY ABOVE<sup>(2)</sup> MAY BE REQUIRED ON -213/-214 INSTALLATIONS<sup>(3)</sup> NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

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Revision: 0

Date: 11.06.15